Date

Thursday, 6/21/2007 2:29:23 PM

Process Sheet

Customer

Job Number

: CU-DAR001 Dart Helicopters Services

: 33061 **Estimate Number** : 10316

P.O. Number

: NIA

This Issue

: 6/21/2007

S.O. No. : مالم

Ma

: 30446

Type : SMALL /MED FAB

Drawing Name

Part Number **Drawing Number** : D2680041 D2680 REV B1

: NUT PLATE

Project Number **Drawing Revision** : N/A ; B1

Material

: NA

Due Date

: 7/28/2007

40 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est: D 04:10.01

Added Steps 2-4, 7-8 KJ/JLM Est Rev:E Now on WaterJet 06-10-12 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M1010S16GA

1010/1025/A21/6aA SHEET

Comment: Qty.:

0.0138 sf(s)/Unit Total:

0.5502 sf(s)

1010/1025/A21/6aA SHEET .063" thk

MIOGUEL

FLOW WATER JET

2.0

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2680

Dwg Rev: 3/ Prog Rev: BL

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

SMALL & MEDIÚM FAB RESOURCE 1

SMALL FAB



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2-C'sink as per Dwg D2680

X40

Dart Aerospa	ace l	_td
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W/O:		WORK ORDER CHANGES								
DATE	STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		•						•		
		·								
Part No:		P	AR #: Fault Category:	N	CR: Yes	No DQ	A:	_ Date: _		
					QA:	N/C Close	d:	_ Date: _		

NCR: WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Description of NC Corre		Section B		Verification Approva	Annessal	Approval
DATE STEP	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Section C	Chief Eng	QC Inspector
		·							
		·							

NOTE: Date & initial all entries

Qate: Thursday, 6/21/2007 2:29:23 PM User: Kim Johnston **Process Sheet** Drawing Name: NUT PLATE Customer: CU-DAR001 Dart Helicopters Services Part Number: D2680041 Job Number: 33061 Job Number: Description: Seq. #: Machine Or Operation: POWDER COATING POWDER COATING 6.0 M 104144 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 7.0 QC3 POWDER COAT/CHEMICAL CONVERSION MS20426AD33 8.0 Comment: Qty.: 80.0000 Each(s) Total: 2.0000 Each(s)/Unit Pick: Part Number Description Batch Qty 111563 2 MS20426AD3-3 Rivet 9.0 MS21069L4 Nutplate 40.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total : Pick: Description Batch Part Number Qty MS21069L4 **Nut Plate** 10.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Install Nut Plate as per Dwg D2680 11.0 QC5 WORK TO CURRENT STEP Comment: INSPECT PACKAGING RESOURCE #1 PACKAGING 1 12.0 Comment: PACKAGING RESOURCE #1 . Identify and Stock Location:

Dart Aerospace	Lta	
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
					·····					
								:		
	<u> </u>							l		

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA: Д	Date: (7/67/09
			QA: N/C (Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					!		
		Description of NC Cor		Corrective Action	tive Action Section B			Approval	Annroval
DATE	STEP	Section A	Initial Chief Eng	Action Descri	tion	Sign & Date	Verification Section C	Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date:

Thursday, 6/21/2007 2:29:23 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Part Number: D2680041

Job Number: 33061 Job Number:

Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE







Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C207/07/09

Dart Aerospac	e l	_td
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE		Ву	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector	
						-				
Part No	:	PAR #: Fault Category:	NCR:		NCR: Yes No DQA: Date:					
				QA:	N/C Close	d:	_ Date: _			

NCR:			WORK ORDE	ER NON-CONFO	RMANC	CE (NCR)			
		Description of NC	corrective Action		Section B		Verification	Annroval	Anneousl
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
								:	

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33061
Description: Nut Plate	Part Number:	D2680-1
Inspection Dwg: D2680 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST									
	X	First Arti	cle _	Prot	otype				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
Ø0.104	+0.004/-0.001	\$0.107			Vern				
Ø0.266	+0.006/-0.001	\$0.269	/		Vern				
Ø0.136	+0.005/-0.001	Ø0.140	/		Vern				
0.370	+/-0.010	O. 373	./		Vern				
0.280	+/-0.010	0,282	"		Vern				
R0.688	+/-0.010	RO,688			R-4				
0.063	+1.0.010	0.05			Vern				

			-						
			:						
_									

Measured by:	5/40	Audited by:	as	Prototype Approval:	N/A
Date:	2106/24	Date:	07/06/25	Date:	N/A

Rev	Date	Change		Revised by	Approv#d_
Α	07.05.31	New Issue	P/O D2680-041	KJ/JLM of	
				• ()	<i>f</i> : <i>f</i>

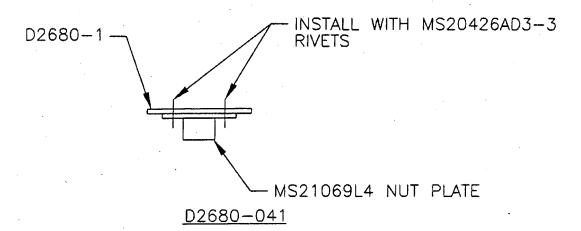


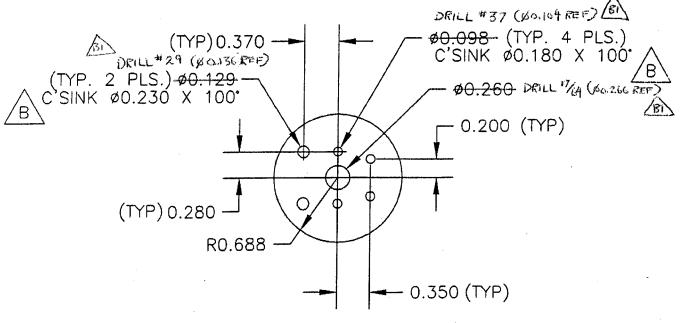


DESIG	4	DRAWN BY	DART AEROSPACE USA, INC.
CHEC	KED	APPROYED	DRAWING NO. REV. B
	φ.	KE	D2680 SHEET 1 OF 1
DATE			TITLE SCALE
 98.1	12.14		NUT PLATE 1:4
Α		97.09.15	NEW ISSUE
R		98 12 14	CHANGE C'SINKS (PER TSR A1041)

TELEASE

98.12.14		NUT PLATE	
Α	97.09.15	NEW ISSUE	
В		CHANGE C'SINKS (PER TSR A1041)	
BI	4-11.04	CHANGE HOLES & FINISH	





ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL MATERIAL:

0.063 THICK (16 GAUGE)

SHOP COPY RETURN TO

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED THE TOLERANCE ARE PER DART QUE D BI POWDER COAT WHITE (4.35.2) PER DART OF 605 43 D2680-1

UNCONTROLLED COP SUBJECT TO AMENDMEN